

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023746**Date Inspected:** 09-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Heavy Dock

This QA Inspector randomly observed the following work in progress onboard the ship moored at the end of the Heavy Dock:

Match drilling of 3 additional 23mm holes located on OBG Segment 12CW at approximate panel point 117.8 at ends of deck plate U-ribs using a 9 hole template. See photo below of template in place immediately after match drilling the 3 holes in one side of one deck plate U-rib.

OBG Trial Assembly Area

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

FCAW welding of weld joints SEG3020C-057; SEG3020B-055 located on PCMK OBG 14W. Welder was identified as 037705. QC was identified as Li Yan Hua (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Wang Xiang Pin (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2232-ESAB as verbally identified by QCA1.

SMAW welding of weld joints BP3061-001-001~012; SEG3013B-187, 188, 194, 195, 201, 202, 208, 209 located

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on PCMK OBG 13AW/13BW, holdback welds at the transverse joint. Welder was identified as 067876. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1 as verbally identified by QCA1.

SMAW welding of weld joint OBW13AD-001 located on PCMK OBG 13AW/13BW, transverse joint. Welders were identified as 067520, 067942. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1 as verbally identified by QCA1.

SMAW welding of weld joint SEG3013U-095 located on PCMK OBG 13AW, holdback weld at the transverse joint to 13BW. Welder was identified as 066396. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1 as verbally identified by QCA1.

SMAW welding of weld joint SEG3014K-101 located on PCMK OBG 13BW, holdback weld at the transverse joint to 13AW. Welder was identified as 066396. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1 as verbally identified by QCA1.

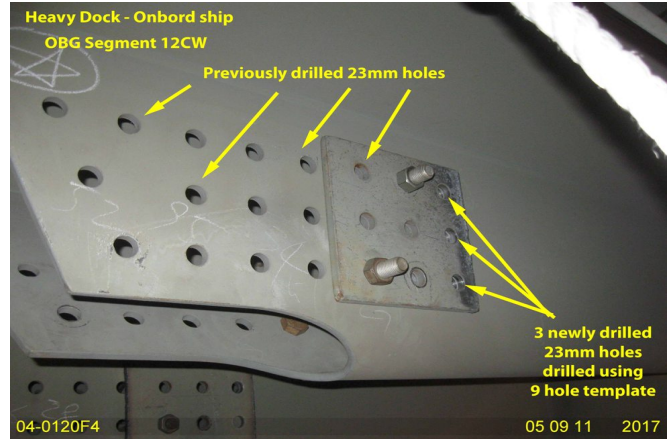
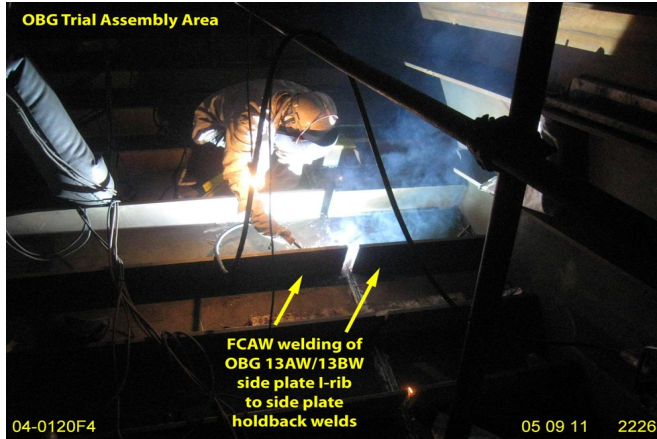
FCAW welding of weld joints SP3092-001-052~061; SP3095-001-001~010 located on PCMK OBG 13AW/13BW, holdback welds at the transverse joint. Welders were identified, respectively, as 066881, 070101. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2132-ESAB as verbally identified by QCA1. See photo below of the welding operation in progress.

SMAW welding of weld joints BP3058-001-013~024; SEG3013B-001, 002, 013, 014, 019, 020, 025, 026, 031, 032, 037, 038 located on PCMK OBG 13AW/13BW, holdback welds at the transverse joint. Welders were identified, respectively, as 066734, 066643. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1 as verbally identified by QCA1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784, who represents the Office of Structural Materials for your project.

Inspected By: Goulet, George

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer